

Work Order ID 74467

Friday, September 30, 2011 1:52:09 PM



Page 1

Item ID: D4019-3

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 9/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/6/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: M.L. J

Date: 11/09/30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4019

D

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4019
2- remove identification marks and deburr

6 SMD 12-04-06

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

6 12-04-06 6x

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

WA

6 SMD 12-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/4/11 [Signature]
WF 12-04-07

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Picklist Print

Friday, September 30, 2011 1:52:18 PM

Page 1

Work Order ID: 74467



Parent Item: D4019-3



Parent Item Name: Rib

Start Date: 9/30/2011

Required Date: 10/6/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg revC
DD 10.04.20 verified by:EC IPP Rev:D as per dwg revD DD 10.08.18
verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6TS0.750W.06

Purchased

No

100

f

172.4533

1.75

11.05263

2



SAD

12-04-06

6061-T6 SQ Tube .75 x .75 x .062W

Location

Loc Qty

Loc Code

MAT006

20.16379

104422

4

116687

1.16379

9671

15

MAT013

152.289506

117400

152.289506

11.05263

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

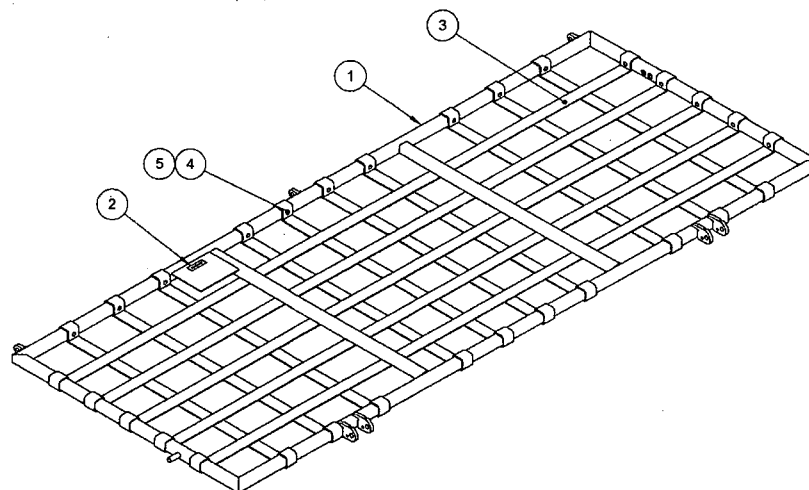
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4019-041	LIGHT LID SHORT BASKET ASSY
1	1	D4019-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-043	WEBBING (SHORT BASKET)
4	30	MS20600AD4W3	BLIND RIVET
5	30	NAS1149DN416J	WASHER



D4019-041 LIGHT LID SHORT BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.83 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. **74467**

M.L.J
11/09/30

RELEASED
10.08.12
ECN 10-596

D	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-243, UPDATED VIEW E ACCORDINGLY (A7-2); REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
C	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B3-2)	JPH	10.04.06
B	BOM: INSERTED QTY 1 D2728-1 AS ITEM 4 & QTY 1 D4088-243 PLACARD AS ITEM 11. ITEMS RENUMBERED AS REQD. DETAIL E ADDED (A7-2) & (D5-2). SECTION B-3 REV'D (D6-3) DIM ADDED (B4-3); WELD SYMBOL REVISED (D5-3)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AKS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AKS</i>		
CHECKED	<i>SC</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AKS</i>	D4019	SHEET 1 OF 4
APPROVED	<i>AKS</i>	TITLE	SCALE
DE APPR.	<i>AKS</i>	LIGHT LID SHORT BASKET	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

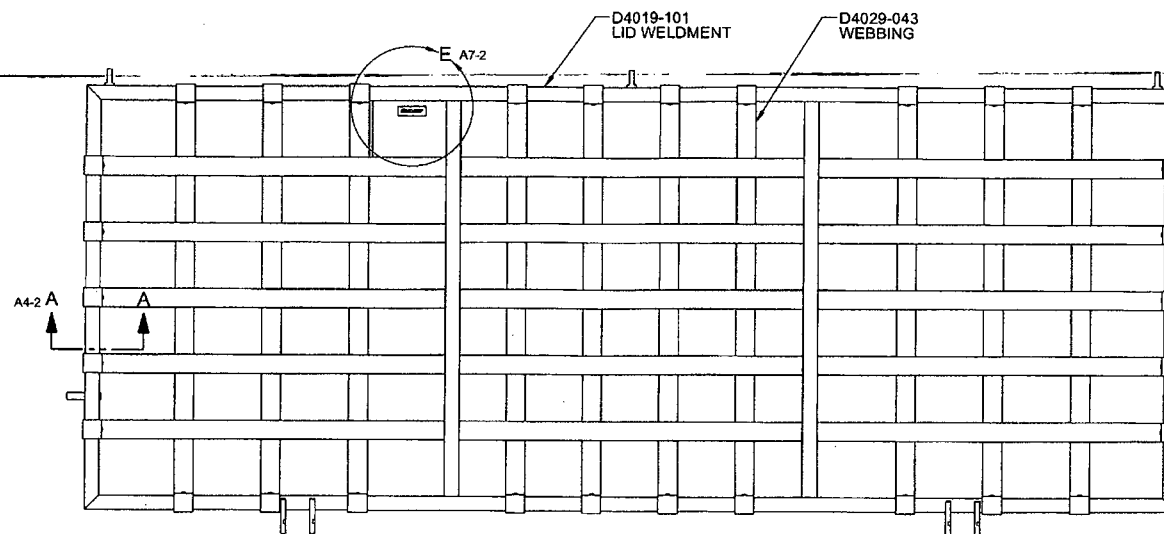
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

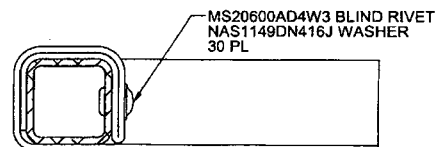
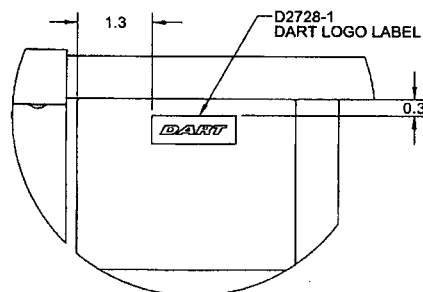
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NOTE: Date & initial all entries

74467



D4019-041 LIGHT LID SHORT BASKET ASSY



SECTION A-A C7-2

RELEASED
10-08-12

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D4019	REV. D
CHECKED	SC	SHEET 2 OF 4	
MFG. APPR.	MS	TITLE	SCALE
APPROVED	MS	LIGHT LID SHORT BASKET	NTS
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DATE	10.08.05		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

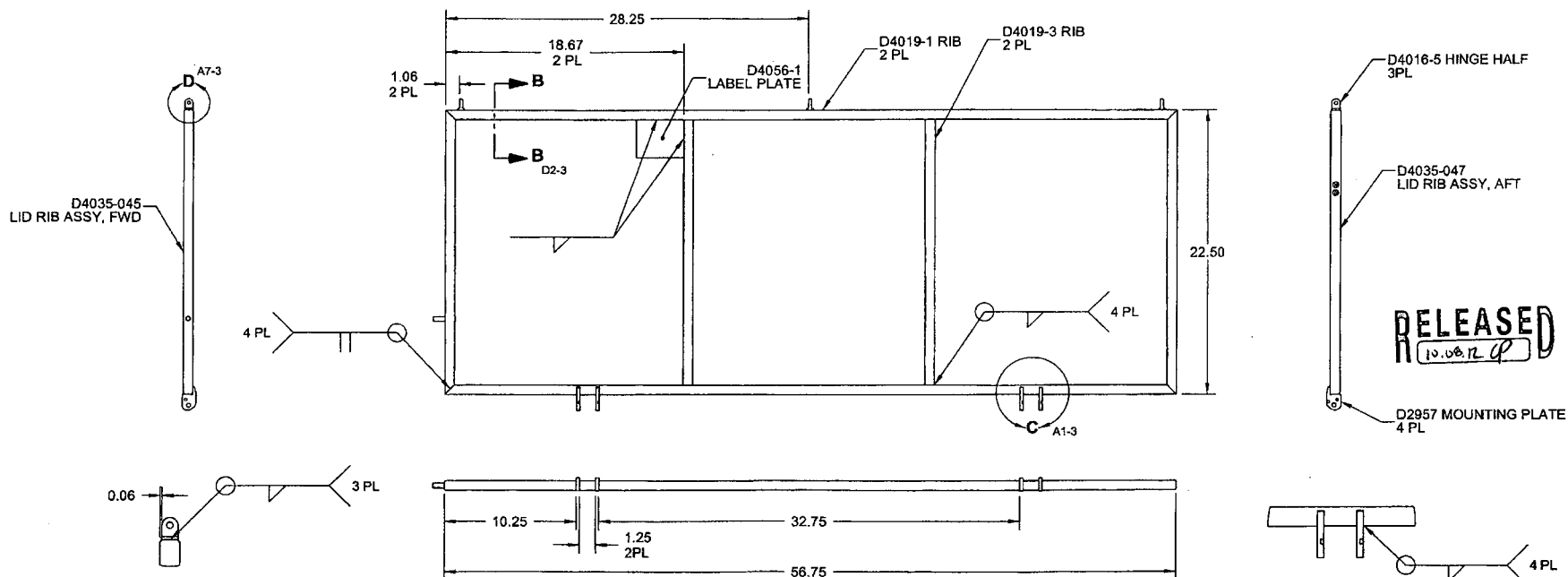
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

74467

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4019-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	3	D4016-5	HINGE HALF, LIGHT LID
3	2	D4019-1	RIB
4	2	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET

SECTION B-B C6-3



DETAIL D C7-3

D4019-101 BASKET LID WELDMENT ASSY

DETAIL C B3-3

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.32 lbs
- 8) WELD PER DART QSI 004

DESIGN	ACS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	SC	D4019	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LIGHT LID SHORT BASKET NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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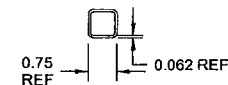
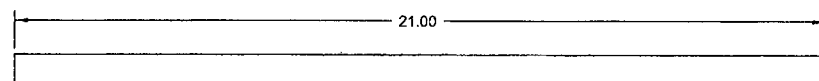
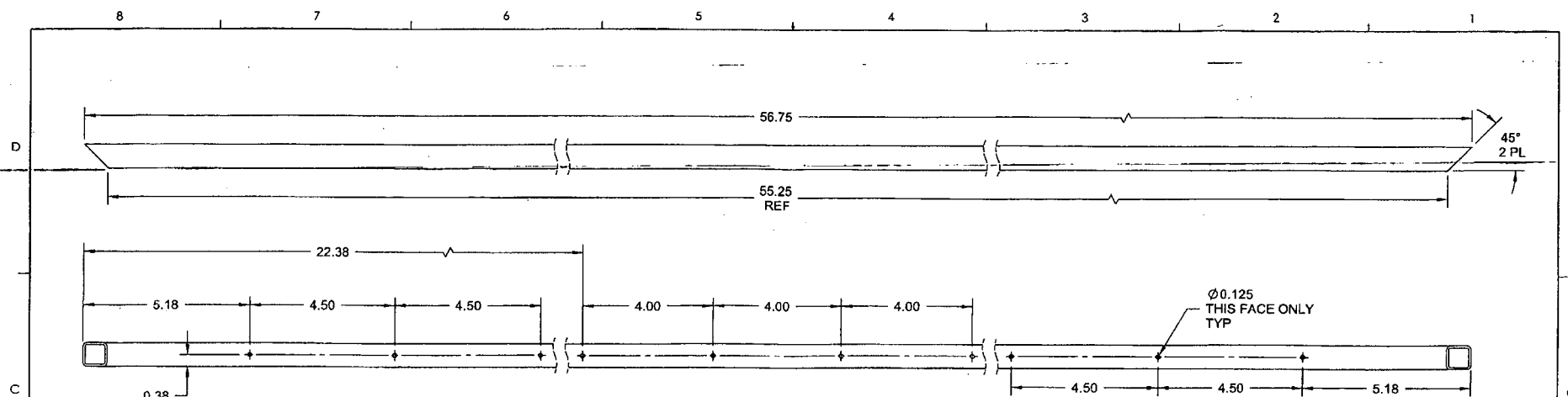
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74467



RELEASED
10.08.12

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.88 lbs
-3: 0.77 lbs

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	Sc	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Sc	DRAWING NO.	REV. I
MFG. APPR.	Sc	D4019	SHEET 4 OF 4
APPROVED	Sc	TITLE	SCALE
DE APPR.	Sc	LIGHT LID SHORT BASKET	
DATE	10.08.05	NTS	
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